

86239

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Date: 12/06/25 Tooling:

Date:

Run Start *NR1*

QC:

Date: / / SPC (Y/N):

Date:

Stop *NR2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86239

June-25-12 10:32:59 AM

86239

Page 2

Item ID: D3565-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 25/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D35652-Weld hard facing as per Dwg D3565 using DT8991 jigA/R 2059B Hard Coat rod Batch: <u>M122279</u>								
140	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

11 12-8-7

11 12-8-7 **DAS 24**

SMB **DAS 16** 12/08/07

11X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 86239

86239

Page 3

June-25-12 10:32:59 AM

Item ID: D3565-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 25/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

3h50

OVEN TEMPERATURE:

121.279 ✓

320 FINISH TIME:

4h20

11 ~~8~~ (2P) 12/08/09.

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

11x ~~50~~ 12-8-10.

180

Identify as per dwg & Stock Location: ST 500

0.00

180

Packaging

Memo

0.00

Packaging

11x ~~8P~~ 12-8-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 86239

86239

Page 4

June-25-12 10:32:59 AM

Item ID: D3565-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 25/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/8/13
MCS 12/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-25-12 10:33:03 AM

Page 1

Work Order ID: 86239

86239

Parent Item: D3565-1

D3565-1

Parent Item Name: Wearplate

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev :A New Issue 07-01-16 JLM
 IPP rev B revB dwg 07.04.18 ec
 IPP Rev:C rev.c as per dwg 08-01-14 DD verified by:
 IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3009-3		Manufactured	No			100	Each	82.0000	3	30			

D3009-3

Cup

**

EL 12-8-7

Location

Loc Qty

Loc Code

WA

32

79078

30

80095

2

WA030

50

83174

50

33

M304S16GA

Purchased

No

130

sf

1.5746

0.135

1.421053

1.5

M304S16GA

304/316 Sheet .063

**

HB 12-7-8

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

122245

⑩

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Dart Aerospace Ltd

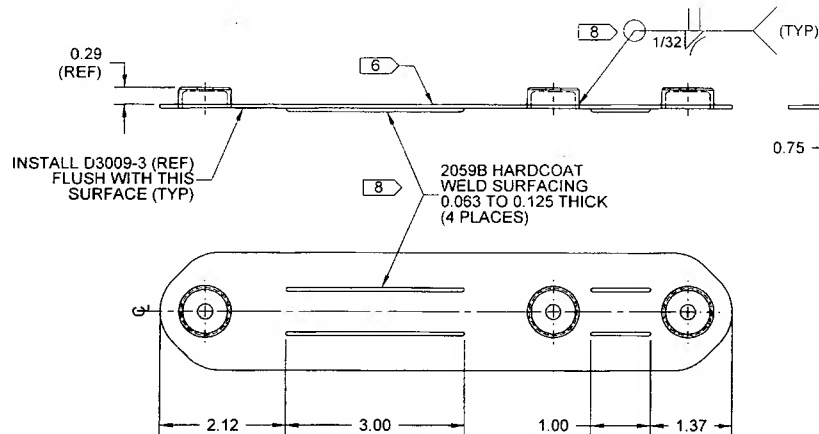
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

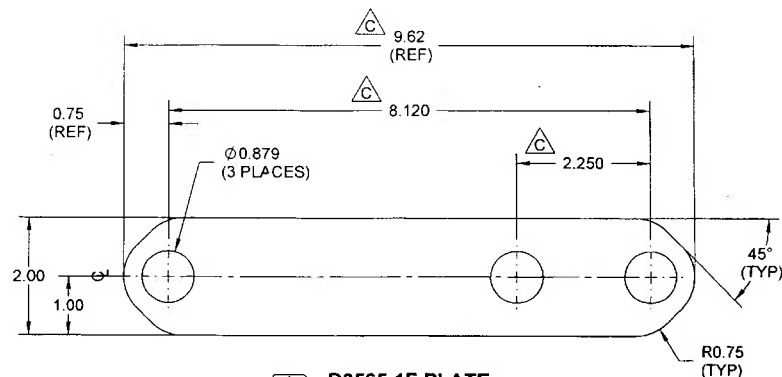
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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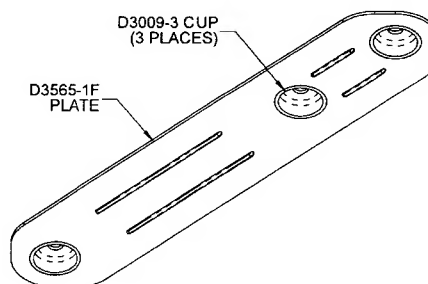
NOTE: Date & initial all entries



D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

QTY	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.38 lbs
 - 8) WELD PER DART QSI 004
 - 9) PART IS SYMMETRIC ABOUT Q

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 06239 M/L
12/06/25

RELEASED
06-21-11/17

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250, ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3565** REV. C
TITLE **R44 WEARPLATE** SCALE 1:2

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